

Date: Monday, 6/5/2006 7:48:06 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE
Job Number	: 27381		
Estimate Number	: 10642		
P.O. Number	: NIA	Part Number	: D31631
This Issue	: 6/5/2006 S.O. No. : NIA	Drawing Number	: D3163 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NIA Type : PURCHASED PARTS	Drawing Revision	: C
Previous Run	: 25022	Material	: NIA
Written By	: <i>See Comment Below</i>	Due Date	: 6/30/2006 Qty: 4 Um: Each
Checked & Approved By	: <i>06.06.05 P</i>		
Comment	: Est. B 05.40.25 Remove Powder Coat KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: *[Signature]*
Email or Ship DXF file to vendor
Laser Cut flat pattern per Dwg D3163
Possible Supplier: GFI
Material release note is required

M2024\$35032 0.032" thick
batch: *M100284*
(1.90 sqft) *M 06 07*

2.0	D31631F Water Jet	Plate
-----	------------------------------	-------



Prog. Rev. *C*
Dwg Rev. *C*



Comment: Qty.: 4.0000 U(s)/Unit Total: 4.0000 U(s)

Plate

M 06 06 07 (4)

3.0	PACKAGING QC2	PACKAGING RESOURCE #1
-----	--------------------------	-----------------------



M 06 07 (4)



Comment: PACKAGING RESOURCE #1

Receive & inspect for Transit Damage
Ensure Material Release Note is attached

4.0	QC8	DIMENSIONAL CHECK
-----	-----	-------------------



J 06 06 08



Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAD 06:06:11

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 04/06/14

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 7:48:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 27381

Part Number: D31631

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAT

OG: 06.06.10

4

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF. 06.06.12

4

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Small Lab C.A.

FF 06.06.13

4

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06.06.14

4

Job Completion



U 26.06.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

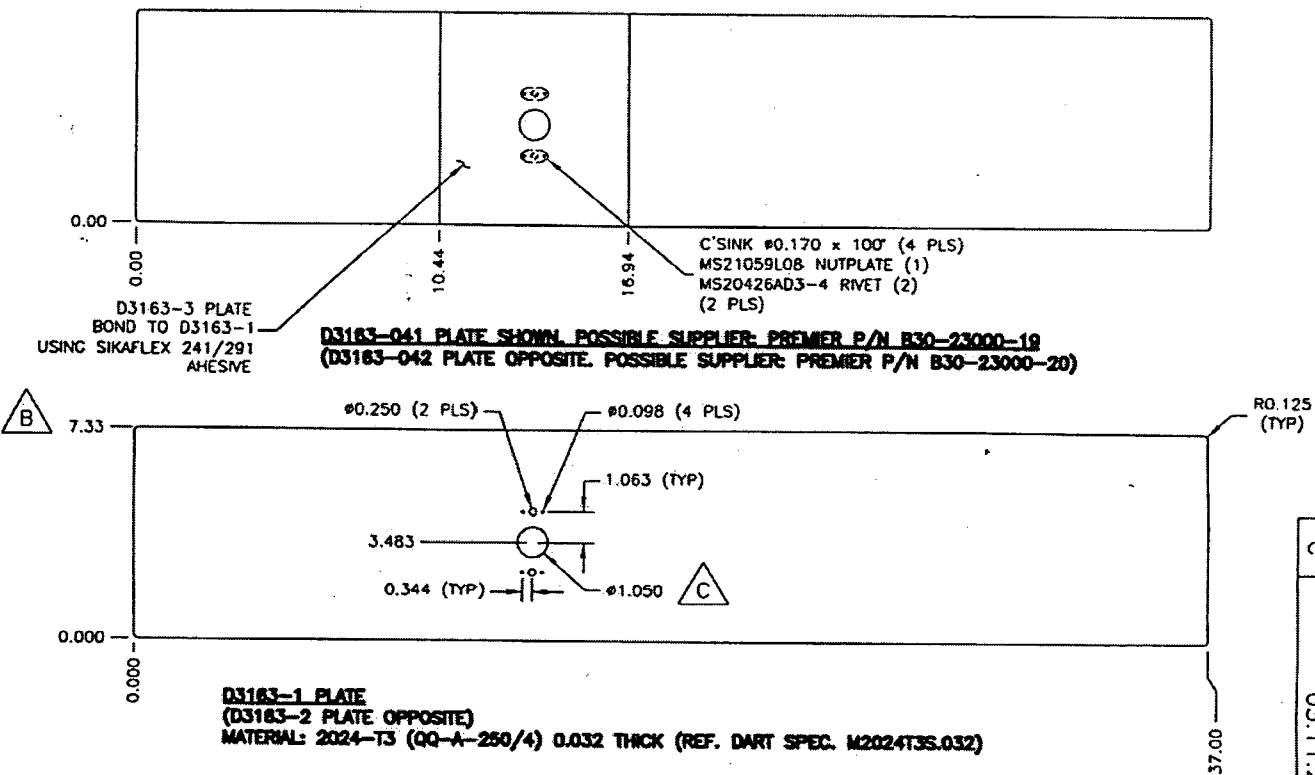
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

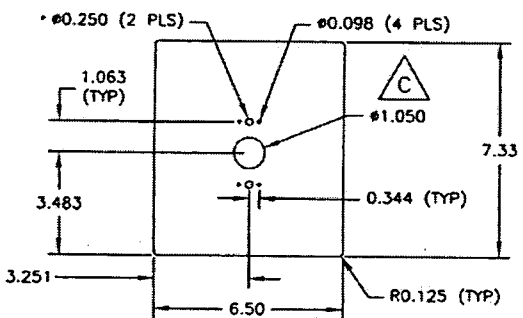
QA: N/C Closed: _____ Date: _____

DART

DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKSBURY, ONTARIO, CANADA
DATE	05.11.22	DRAWING NO.	D3163	REV. C
		TITLE	PLATE	SHEET 1 OF 1
		SCALE	1:6	
A		02.04.26	NEW ISSUE	
B		04.10.06	7.33 WAS 7.20; REMOVE PERIMETER HOLES	
C		05.11.22	Ø1.050 WAS Ø1.000	



D3163-1 PLATE
(D3163-2 PLATE OPPOSITE)
MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (REF. DART SPEC. M2024T3S.032)



D3163-3 PLATE
MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)

GENERAL NOTES:

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) BREAK SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 27381

RELEASED
05.12.08

